



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D119-646-241
Job Sheet 166774



LH

Part No: D119-646-241

Job Qty: 1 ea

Part Name: AW119 Replacement Skidtube with Heavy Duty Wearplates - Fits LH or RH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/16/17

Job Tracking No:

Due Date: 11/10/17

Created By: Victoria Michaud-Febrille

Type: Stock

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	1 Ea		11/9/17	0.00	0.00	Start up container	
110	Skidtubes	1 pcs		11/9/17	0.77	0.05	Skidtubes	
120	HandFinish	1 pcs		11/9/17	0.00	0.79	HandFinish1	
121	QC	1 pcs		11/9/17	0.00	0.00	QC7	BE
122	QC	1 pcs		11/9/17	0.00	0.00	QC5	BE
130	Skidtubes	1 pcs		11/9/17	0.00	2.38	Skidtubes	
135	QC	1 pcs		11/9/17	0.00	0.00	QC5	BE
140	Skidtubes	1 pcs		11/9/17	0.00	2.38	Skidtubes	MKG
150	QC	1 pcs		11/9/17	0.00	0.00	QC5	BE
160	Skidtubes	1 pcs		11/9/17	0.00	2.44	Skidtubes	BE
170	QC	1 pcs		11/9/17	0.00	0.00	QC5	38
180	QC	1 pcs		11/9/17	0.00	0.00	QC10	38
190	HandFinish	1 pcs		11/9/17	0.00	0.33	HandFinish2	2017-11-20 7:50
200	Powdercoat	1 pcs		11/9/17	0.00	0.20	Powdercoat	171205
210	QC	1 pcs		11/9/17	0.00	0.00	QC3	121206
240	HandFinish	1 pcs		11/9/17	0.00	0.79	HandFinish4	171207
250	QC	1 pcs		11/9/17	0.00	0.00	QC5	38
255	HandFinish	1 pcs		11/10/17	0.00	0.20	HandFinish3	1712107
256	QC	1 pcs		11/10/17	0.00	0.00	QC5	38
258	DC	1 pcs		11/10/17	0.00	0.00	DC	38
260	Packaging	1 pcs		11/10/17	0.00	0.00	Packaging3	31
270	QC21-FG	1 Ea		11/10/17	0.00	0.00	QC21	330 DEC 20 2017

Part Op 110 - 1- inspect Mat'L D2500-1-190 for damage 2-Cut tube to length as per dwg D3887 (154.8") 3- Ensure squareness of Descriptions: ends and scribe batch#

130 - ~~1~~ Install drill Jig DT9477 drill X-bolt spacer pilot holes using 3/16" drill first side only. ~~2~~ 2nd side, locating from first saddle holes use DT9861 A/B to drill 2nd side fwd saddle holes. ~~3~~ 2nd side locating from fwd saddle drill remaining crossbolt spacer holes usin DT9477. ~~4~~ Open crossbolt spacer holes to finished size as per dwg D3887 (section D-D and E-E) ***DO NOT OPEN FWD Saddles Holes*** 5- Deburr, blow out chips from inside of tube. 6- Bond web in place as per Dwg D3887 & QSI 015. A/R Sikaflex-291 ~~138535~~ Sikaflex expire date: ~~18-04-21~~ Start: date 17-10-23 Time: _____ Finish: _____ Time: _____ ***** (Adhere for 12 hours) *****

140 - ~~1~~ Bend FWD end of tube using bender 1 and bend prog. D3887. ***Must use bending aid DT9544, ensure proper positioning*** ~~2~~ Cut FWD end of tube as per dwg D3887. ***Verify measurement*** 3- Buff out marks left from bending ~~4~~ Drill FWD cap holes using DT8215. Open FWD & AFT cap holes to 0.208" ~~5~~ Open FWD saddle holes to finished size as per dwg D3887 ~~6~~ Drill FWD x-bolt spacer holes using DT9816 and open to finished size. (verify measurement) ~~7~~ Drill Tow ring hole, using DT10047 locate from FWD saddle hole. (verify measurement). Open to finished size. ~~8~~ Drill 1.87" and 3.74 holes using DT10045 A&B locate from FWD saddle hole. (verify measurement) as per dwg. ~~9~~ C'sink FWD cap hole as per detail "C" ~~10~~ Countersink crossbolt spacer holes, and prepare tube for welding, deburr. 11- Deburr and blow

S000847



PART NO: D119-646-241

Revision:

Operation: Start up Operation

Quantity: 1

Change No:

Mfg Date: 10/18/17

Job No: 166774

out chips from inside of tube.

160 - NOTE:TACK IN 2 MOST FWD X-BOLT SPACERS AND TEST FIT FWD GROUND HANDLING FIXTURE,IF FIXTURE FITS WELL THEN PROCEED. FIXTURE DT10091. 1-Insert crossbolt spacers. Weld as per QSI 004 and Dwg D3887. Remember to back drill each hole before welding the other side. Use aluminum rod A/R Aluminum Rod 137/33 2-Grind cross bolt welds flush as per Dwg D3887. Ensure no pin hole. 3-Counterbore x-bolt spacer holes as per Dwg D3887 using DT10279. 4-Deburr and blow out chips from inside of tub 5- Pick D2855-5 cap and transfer drill missing hole. Deburr and identify cap with skidtube batch#.

170 - TEST FIT USING FIXTURE DT10091.

200 ***MASK AREA SHOWN ON SHEET 7, NOTE 9*** START TIME: 1:30 OVEN TEMPERATURE: 320° FINISH TIME: 2:00 M138467

240 - 1-Install wearplates as per Dwg D3887. 2 -Inspect for foreign objects as per QSI 024 3 -Install D2855-3 Cap and seal with Sikaflex. Clean excess adhesive. A/R Sikaflex-240/-291 _____ Sikaflex expire date: _____ 4

-Install insert in D2855- Cap. Install cap and seal with Sikaflex. Clean excess adhesive. A/R Sikaflex-240/-291

_____ Sikaflex expire date: _____

258 - Photocopy bluefile & type labels per PPP D119-646-241 CHG003

260 - Location : FG084

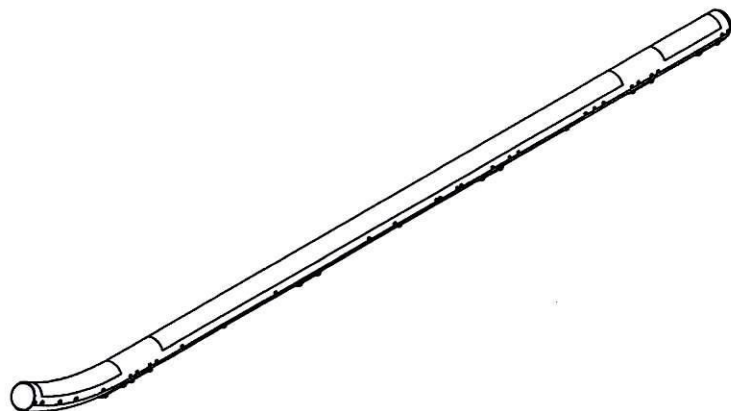
Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D2500-1-190	1	138	0	0
140-Skidtubes	D2579 <u>1620059717</u>	2	56	0	0
	D3885-1B <u>162925</u>	1	24	0	0
160-Skidtubes	D3681-1 <u>165379</u>	12	136	0	0
	D3903-1 <u>165654</u>	12	171	0	0
240-HandFinish <u>FM135948-2</u>	ALS4-1032-225	1	388	0	0
	AN3C46A <u>FM138009-1</u>	8	175	0	0
	AN3C5A <u>FM137710-1</u>	2	205	0	0
	D2855-3 <u>F153291</u>	1	42	0	0
	D2855-5 <u>166541</u>	1	14	0	0
<u>D3492-5 / F163302</u>	B3492-045 V	8	48	0	0
	D3672-1 <u>F150074</u>	2	1,799	0	0
	D3849-041 <u>5002082</u>	1	3	0	0
	D3849-043 <u>5000706</u>	1	5	0	0
	D3904-1 <u>F165620</u>	16	144	0	0
<u>FM136182-41</u>	MS21043-3	8	917	0	0
<u>FM138409-1</u>	MS24694-C52 <u>FM137951</u>	2	101	0	0
	NAS1149C0332R	2	2,674	0	0

Part Specifications

Specifications could not be found.

Plex 10/17/17 2:45 PM dart.Michaud-Febrille.Victoria



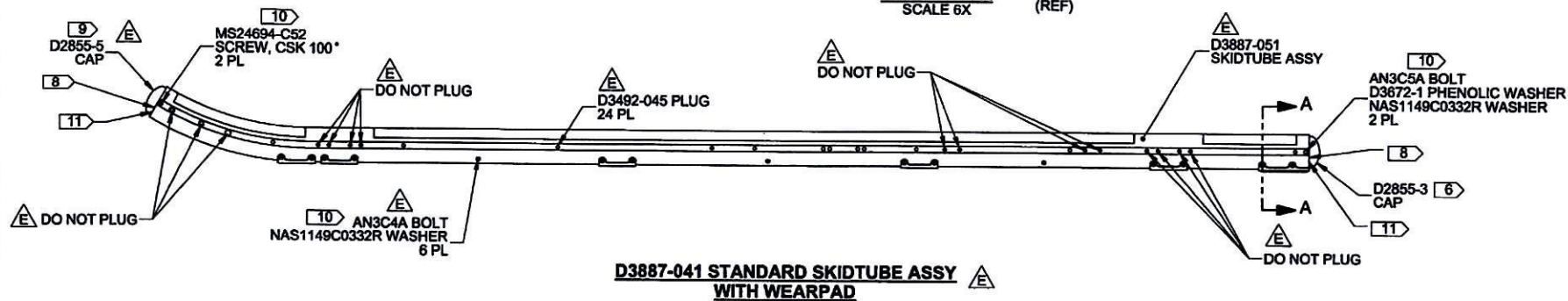
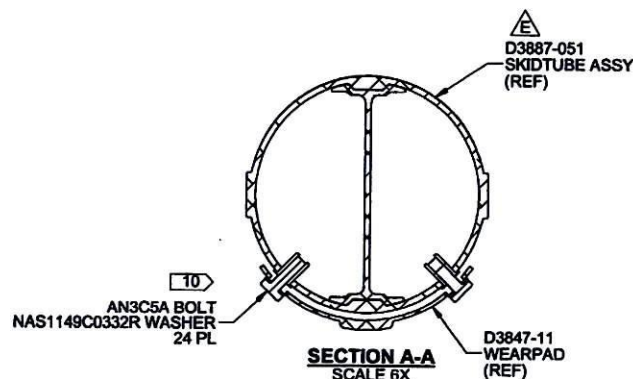
D3887-041 STANDARD SKIDTUBE ASSY WITH WEARPAD(SHOWN)
D3887-043 STANDARD SKIDTUBE ASSY WITH WEARPLATE (SIMILAR)
D3887-045 STANDARD SKIDTUBE ASSY WITH TRAINING WEARPLATE (SIMILAR)

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 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 166774

E	COMPLETE REDRAW, ADDED ASSY DETAILS -3, -051 & -053, SEE PREVIOUS REV. FOR DETAIL. POWDER COAT REMOVED FROM SADDLE AREA SEE DETAIL F, REF PART 15-421. ADDED STRUCTURAL PROVISIONS TO ALLOW FOR THE INSTALLATION OF THE D119-648-313/314 SKIDTUBE PROTECTOR KIT. REF PART 17-577. CHANGE QTY OF D2855-3, ADDED D2855-5 CAP ASSEMBLIES, ADDED INSTRUCTIONS TO LOCATE INSERT HOLE FOR D2855-5 CAP. REF PART 17-583	AJS / WK	17.02.03
D	REVISED BEND TOLERANCES FOR MANUFACTURABILITY, 135.07 WAS 134.04 (ZN D5-8), ADD 5.07 (ZN C2-8), ADD 118.8 (ZN D5-8), DELETE GASKETS (BOM, SH 2)	DB	13.09.20
C	(SHT1, P/L, ZN C2-2, C3-2, C4-2) ITEM 13, QTY 2 WAS 4, ITEM 42, QTY 32 WAS 34, ITEM 44, QTY 30 WAS 32, ADD ITEM 46, MS24694-C52 WAS AN3C5A, 2 PLCS, (ZN C1-5, C1-6, B4-7) Ø0.201 CSK Ø0.385 X 100° WAS Ø0.214 THRU, ADDED DETAIL F (ZN C8-5, C8-6, B8-7), ADD ITEM 10, D2579 CROSS BOLT SPACER (ZN D4-1, A6-7)	DB	13.02.19
B	ALS4-1032-130 WAS AELS-1032-130 (ZN C4-1, C5-7, C3-7); ADD DT8931 (ZN A8-1); ADD 134.04 (ZN C4-8); D2855-3 WAS D2575 (ZN D4-1, C7-2, C2-2, C7-3, C2-3, C7-4, C2-4); AN3C5A WAS AN3C4A (ZN C8-2, C2-2, C8-3, C2-3, C8-4, C2-4); Ø0.313 WAS Ø0.328 (ZN C4-5, C4-5, C2-7 & B3-7) REVISED NOTE iv (ZN B3-7)	RF	09.06.30
A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC. EUGENE, OR	
DRAWN	WK		
CHECKED	RF	DRAWING NO.	REV. E
MFG. APPR.	DD	D3887	SHEET 1 OF 11
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	A119 STD SKIDTUBE ASSY	NTS
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RELEASED
 2017-05-08
 Cw 17-519

ITEM	QTY	P/N	DESCRIPTION
	X	D3887-041	STANDARD SKIDTUBE ASSY WITH WEARPAD
1	1	D2855-3	CAP ASSY
2	1	D2855-5	CAP ASSY
3	24	D3492-045	PLUG ASSY
4	2	D3672-1	PHENOLIC WASHER
5	5	D3847-1	WEARPAD
6	1	D3847-11	WEARPAD
7	1	D3887-051	SKIDTUBE ASSY
8	1	ALS4-1032-225	INSERT
9	26	AN3C5A	BOLT
10	6	AN3C4A	BOLT
11	2	MS24694-C52	SCREW, CSK 100°
12	32	NAS1149C0332R	WASHER

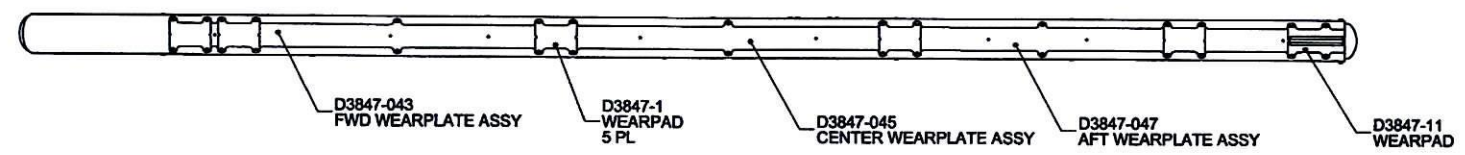
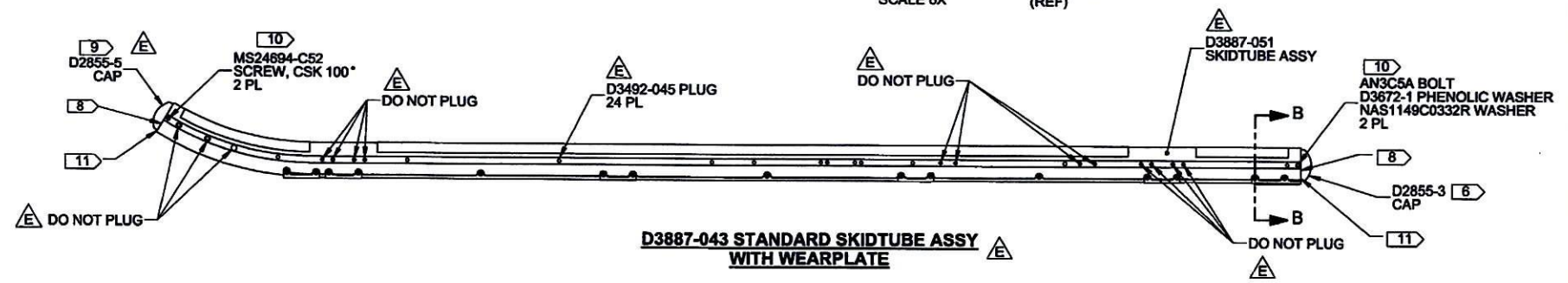
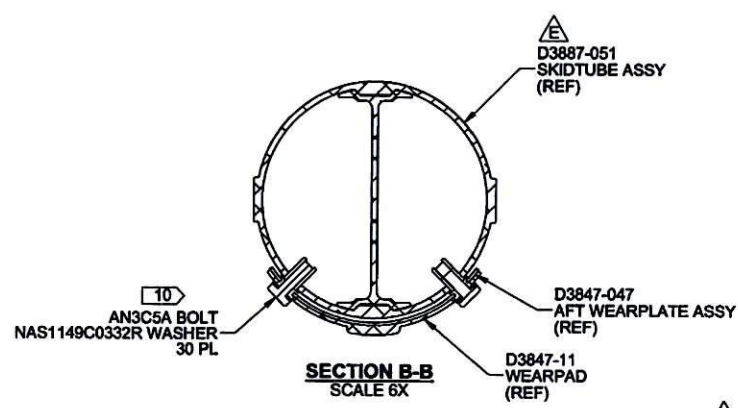


- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3887-041" AND BATCH NUMBER PER QSI 044 6.4 ON THE ID OF THE TUBE, BEFORE INSTALLING THE AFT D2855-3 CAP
 - 7) WEIGHT: 32.0 lbs
 - 8) RELIEVE INNER RIDGE OF EXTRUSION, AS NEEDED, TO ALLOW FOR INSTALLATION OF D2855-3 AND D2855-5 CAP ASSY, ALODINE BARE MATERIAL
 - 9) USE D3887-051 SKIDTUBE ASSY TO LOCATE AND BACKDRILL UNDRILLED INSERT HOLE INTO D2855-5 CAP. OPEN HOLE TO Ø0.297, ALODINE BARE MATERIAL AND INSTALL ALS4-1032-225 (OR AKS7-1032-225, OR ALS7-1032-225, OR AKS4-1032-225) INSERT ON INSIDE OF CAP.
 - 10) SEAL FASTENERS WITH SIKAFLEX -241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT
 - 11) SEAL MATING SURFACES WITH SIKAFLEX -241/291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT

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ITEM	QTY	P/N	DESCRIPTION
	X	D3887-043	STANDARD SKIDTUBE ASSY WITH WEARPLATE
1	1	D2855-3	CAP ASSY
2	1	D2855-5	CAP ASSY
3	24	D3492-045	PLUG ASSY
4	2	D3672-1	PHENOLIC WASHER
5	1	D3847-043	FWD WEARPLATE ASSY
6	1	D3847-045	CENTER WEARPLATE ASSY
7	1	D3847-047	AFT WEARPLATE ASSY
8	5	D3847-1	WEARPAD
9	1	D3847-11	WEARPAD
10	1	D3887-051	SKIDTUBE ASSY
11	1	ALS4-1032-225	INSERT
12	32	AN3C5A	BOLT
13	2	MS24894-C52	SCREW, CSK 100*
14	32	NAS1149C0332R	WASHER

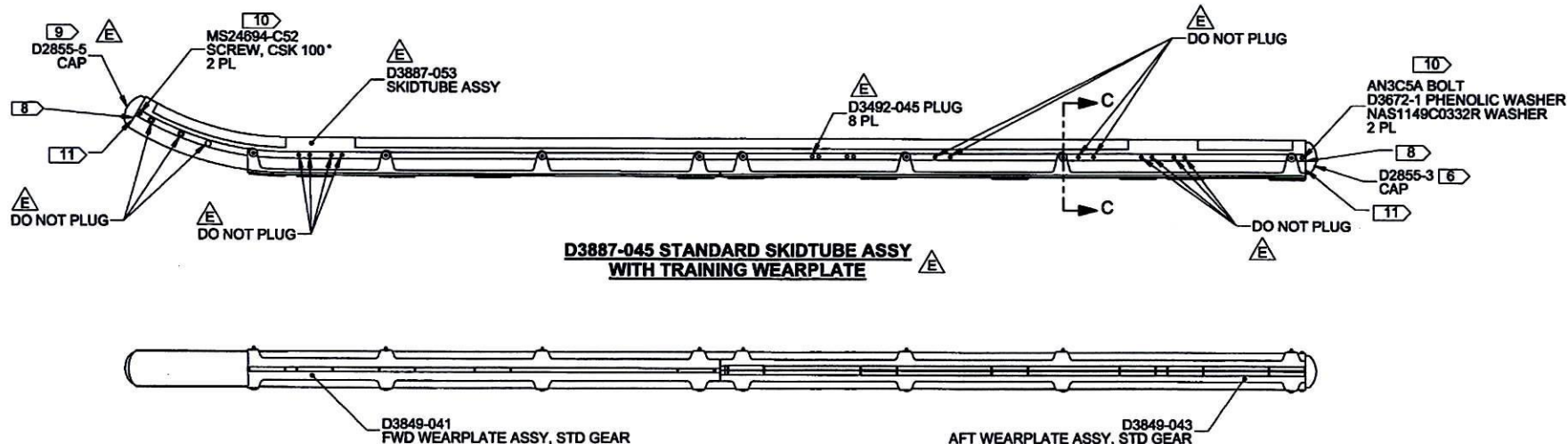
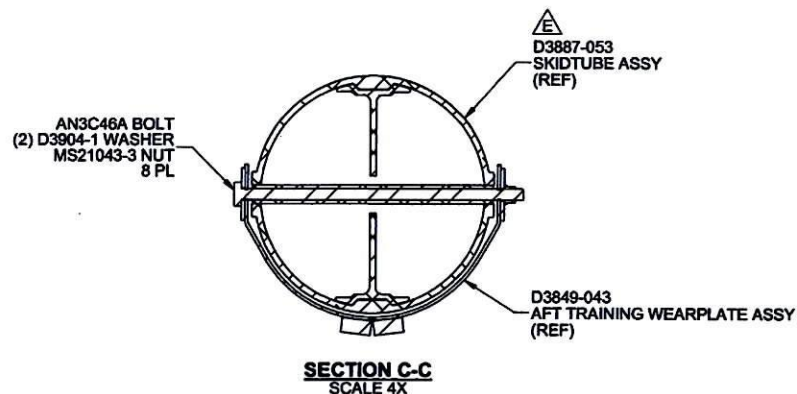


- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3887-043" AND BATCH NUMBER PER QSI 044 6.4 ON THE ID OF THE TUBE, BEFORE INSTALLING THE AFT D2855-3 CAP
 - 7) WEIGHT: 37.0 lbs
 - 8) RELIEVE INNER RIDGE OF EXTRUSION, AS NEEDED, TO ALLOW FOR INSTALLATION OF D2855-3 AND D2855-5 CAP ASSY, ALODINE BARE MATERIAL
 - 9) USE D3887-051 SKIDTUBE ASSY TO LOCATE AND BACKDRILL UNDRILLED INSERT HOLE INTO D2855-5 CAP. OPEN HOLE TO Ø0.297, ALODINE BARE MATERIAL AND INSTALL ALS4-1032-225 (OR AKS7-1032-225, OR ALS7-1032-225, OR AKS4-1032-225) INSERT ON INSIDE OF CAP.
 - 10) SEAL FASTENERS WITH SIKAFLEX -241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT
 - 11) SEAL MATING SURFACES WITH SIKAFLEX -241/291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT

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ITEM	QTY	P/N	DESCRIPTION
	X	D3887-045	STANDARD SKIDTUBE ASSY WITH TRAINING WEARPLATE
1	1	D2855-3	CAP ASSY
2	1	D2855-5	CAP ASSY
3	8	D3492-045	PLUG
4	2	D3672-1	PHENOLIC WASHER
5	1	D3849-041	FWD WEARPLATE ASSY, STD GEAR
6	1	D3849-043	AFT WEARPLATE ASSY, STD GEAR
7	1	D3887-053	SKIDTUBE ASSY
8	16	D3904-1	WASHER
9	1	ALS4-1032-225	INSERT
10	8	AN3C46A	BOLT
11	2	AN3C5A	BOLT
12	8	MS21043-3	NUT, SELF-LOCKING
13	2	MS24694-C52	SCREW, CSK 100°
14	2	NAS1149C0332R	WASHER



NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3887-045" AND BATCH NUMBER PER QSI 044 6.4 ON THE ID OF THE TUBE, BEFORE INSTALLING THE AFT D2855-3 CAP
- 7) WEIGHT: 38.1 lbs
- 8) RELIEVE INNER RIDGE OF EXTRUSION, AS NEEDED, TO ALLOW FOR INSTALLATION OF D2855-3 AND D2855-5 CAP ASSY, ALODINE BARE MATERIAL
- 9) USE D3887-053 SKIDTUBE ASSY TO LOCATE AND BACKDRILL UNDRILLED INSERT HOLE INTO D2855-5 CAP. OPEN HOLE TO Ø0.297, ALODINE BARE MATERIAL AND INSTALL ALS4-1032-225 (OR AKS7-1032-225, OR ALS7-1032-225, OR AKS4-1032-225) INSERT ON INSIDE OF CAP.
- 10) SEAL FASTENERS WITH SIKAFLEX -241/291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT
- 11) SEAL MATING SURFACES WITH SIKAFLEX -241/291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT

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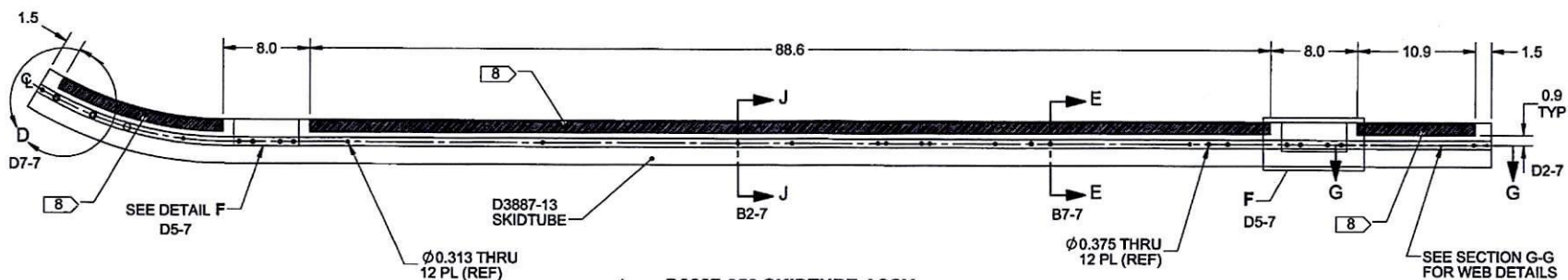
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2017-05-08
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ITEM	QTY -053	P/N	DESCRIPTION
	X	D3887-053	SKIDTUBE ASSY
1	2	D2579	CROSS BOLT SPACER
2	12	D3681-1	CROSS BOLT SPACER
3	1	D3885-1	STANDARD WEB
4	1	D3887-13	SKIDTUBE
5	12	D3903-1	CROSS BOLT SPACER



D3887-053 SKIDTUBE ASSY
(WELDING DETAIL)

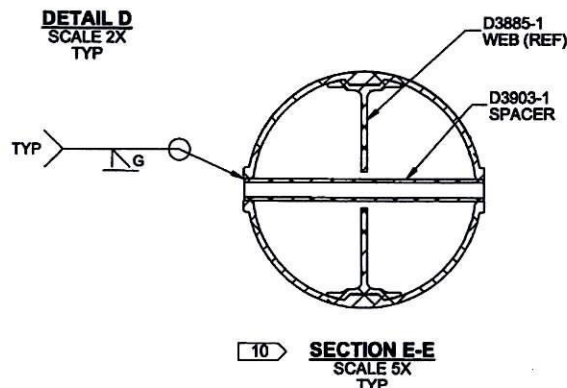
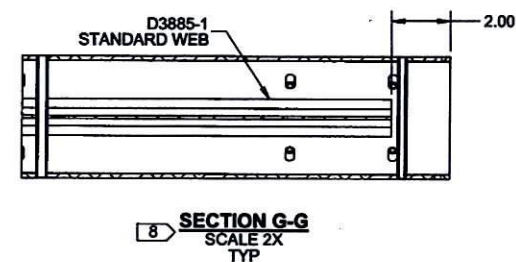
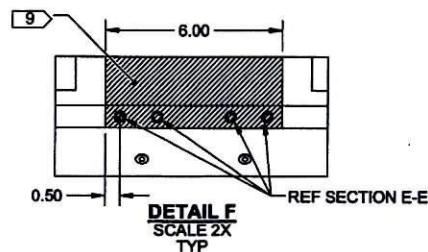
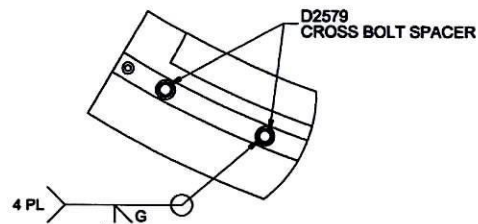
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY AT NEXT ASSEMBLY
- 7) WEIGHT: N/A
- 8) AFTER APPLICATION OF FINISH, PAINT TOP SURFACE OF SKIDTUBE WITH MIL-W-5044 ANTI-SKID PAINT (WING WALK) AS INDICATED TO 0.50 ABOVE LOCATION RIDGE, PER QSI 005 SECTION 4.4

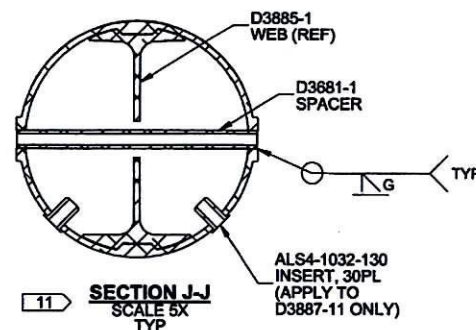
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(FOR 12X $\phi 0.375$ HOLES
PER SKIDTUBE)



(FOR 12X $\phi 0.313$ HOLES
PER SKIDTUBE)

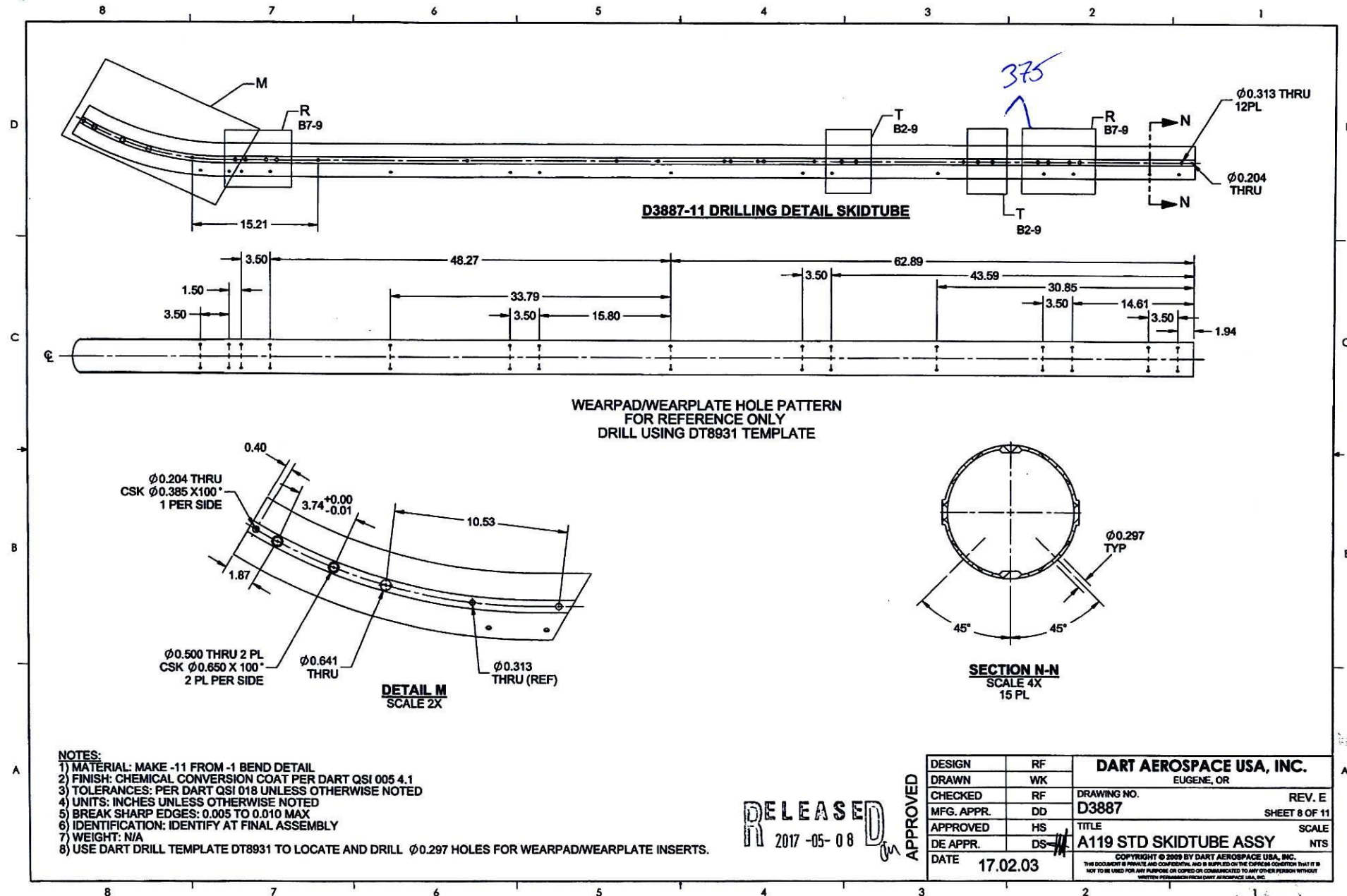
NOTES:

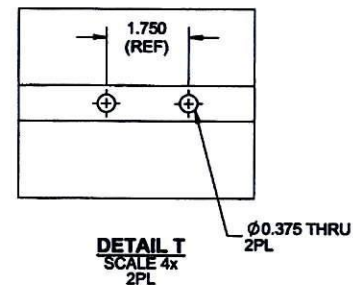
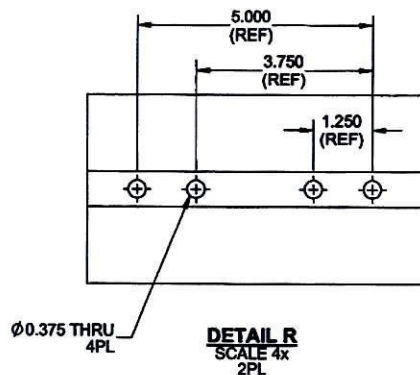
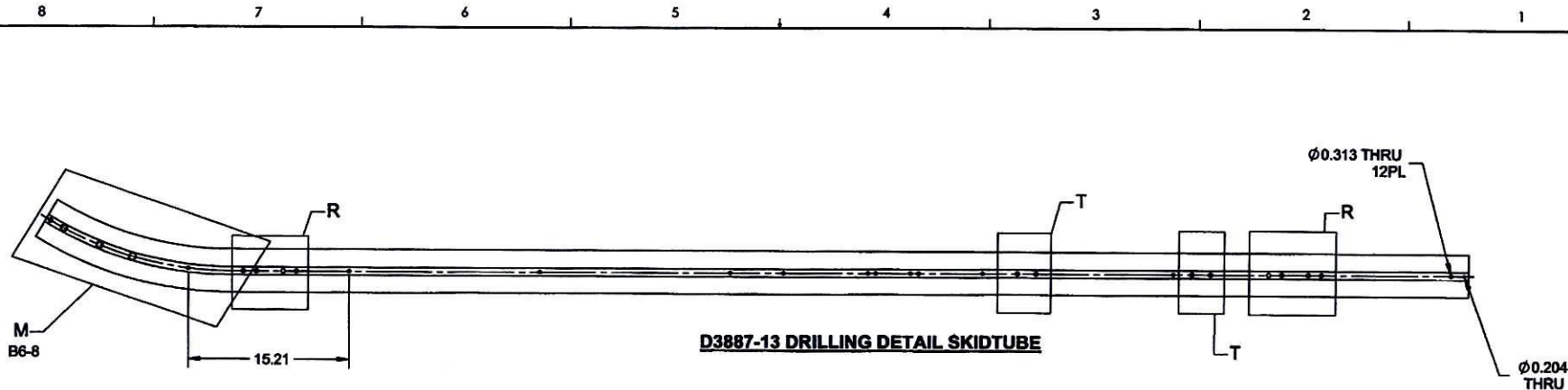
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AT FINAL ASSEMBLY
- 7) WEIGHT: N/A
- 8) INSERT D3885-1 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015 AFTER BENDING. ENSURE HOLES LINE-UP
- 9) MASK THIS AREA AND DO NOT POWDER COAT
- 10) AFTER DRILLING AND BENDING ASSEMBLY, PERFORM THE FOLLOWING FOR THE SECTION E-E $\phi 0.375$ HOLES ONLY:
 - i) CHAMFER HOLES $\phi 0.475 \times 45^\circ$
 - ii) INSERT D3903-1 SPACER
 - iii) WELD INTO PLACE AND GRIND FLUSH
 - iv) C'BORE TO $\phi 0.313 \times 0.75$ DEEP
 - v) DEBURR HOLES
- 11) AFTER DRILLING AND BENDING ASSEMBLY, PERFORM THE FOLLOWING FOR THE SECTION J-J $\phi 0.313$ HOLES ONLY:
 - i) CHAMFER HOLES $\phi 0.354 \times 45^\circ$ OR 0.050 DEEP $\times 45^\circ$ (BOTH SIDES)
 - ii) INSERT D3681-1 SPACER
 - iii) WELD INTO PLACE AND GRIND FLUSH
 - iv) DEBURR HOLES
- 12) WELD PER DART QSI 004

RELEASED
2017-05-08

APPROVED

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	WK	EUGENE, OR	
CHECKED	RF	DRAWING NO.	REV. E
MFG. APPR.	DD	D3887	SHEET 7 OF 11
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	A119 STD SKIDTUBE ASSY	NTS
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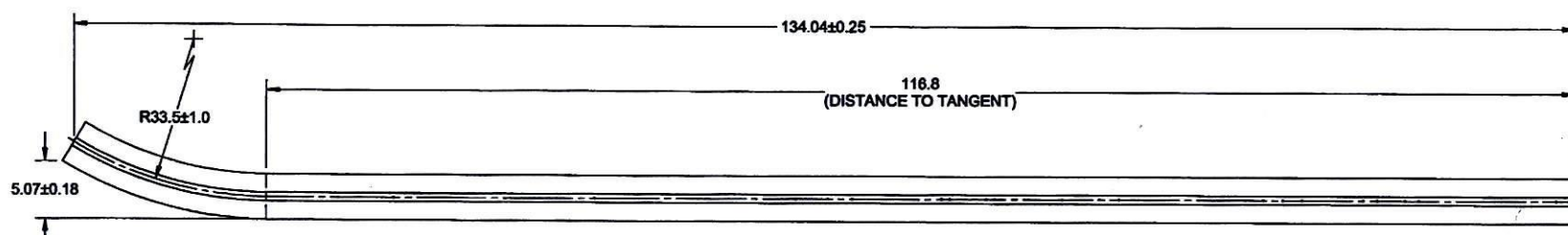
- NOTES:**
- 1) MATERIAL: MAKE -13 FROM -1 BEND DETAIL
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY AT FINAL ASSEMBLY
 - 7) WEIGHT: N/A

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2017-05-08

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CHECKED	RF	DRAWING NO. D3887	REV. E
MFG. APPR.	DD	SHEET 9 OF 11	
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134.1875



D3887-1 BEND DETAIL SKIDTUBE

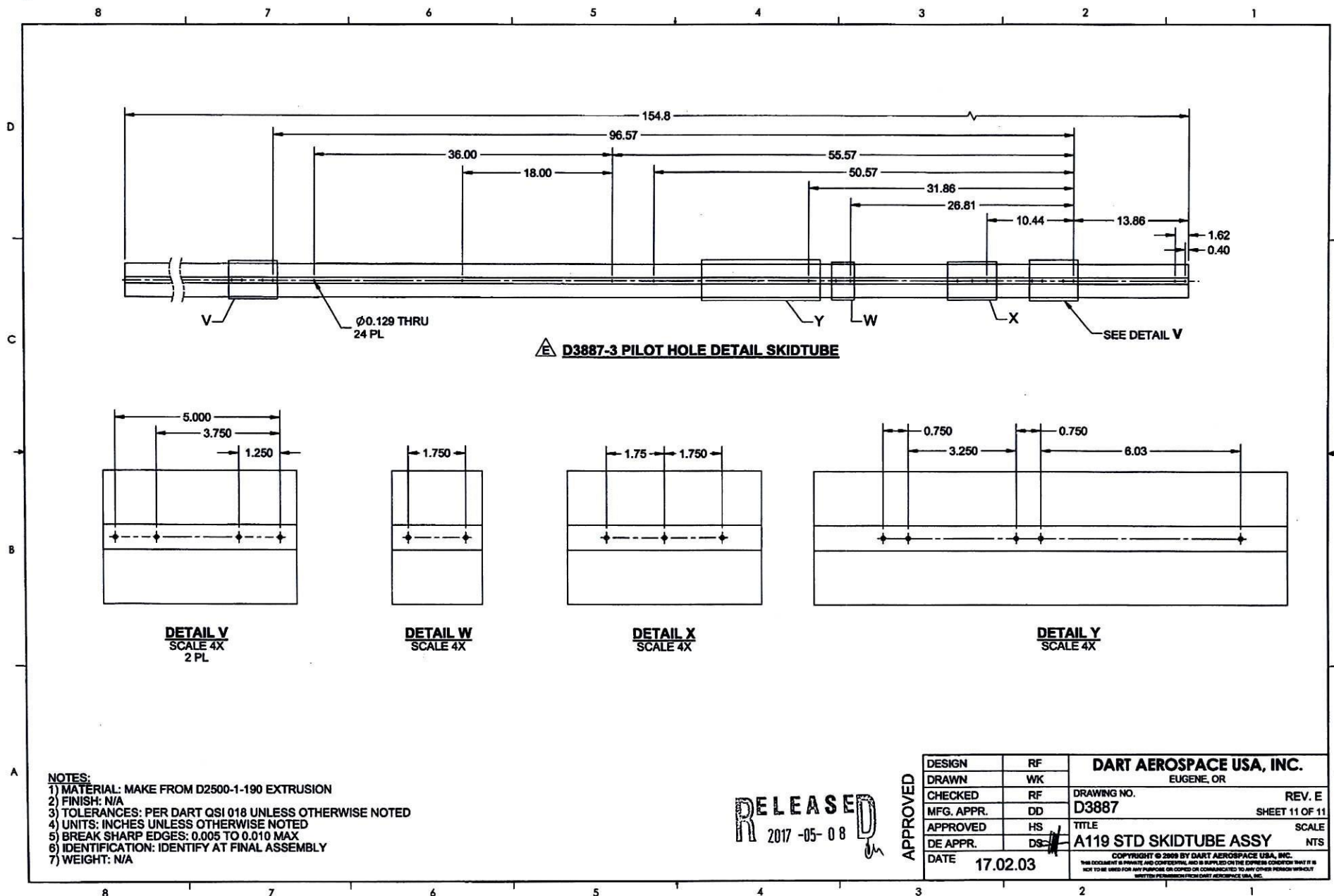
NOTES:

- 1) MATERIAL: MAKE -1 BEND DETAIL FROM -3 PILOT HOLE DETAIL
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AT FINAL ASSEMBLY
- 7) WEIGHT: N/A
- 8) DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 8.5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP 0.020" DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.

RELEASE
2017-05-08

APPROVED

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Time Sheet Adjustment

Name:

BELLIOTT

Date:

17-10-13

ATTENDANCE LOG IN/OUT ADJUSTMENT (Payroll)

Date	Description	LOG IN	LOG OUT
	BK66774		
	S 000847		

Total of Accumulated Hours:

/Hours Total

WORK ORDER ADJUSTMENT (Jobs)

WO #	Sequence#	Description	Started	Finished
166774	110	1,2,3	8:00	8:30
166774	120	deoxidizer / Alodine	3:00	3:20
166774	130	1,2,3	8:20	9:00
166774	130	4,5,6	7:00	8:00

(Supervisor)